

Work Order ID 55841

February 3, 2010 10:46:46 AM



Page 1

Item ID: D3826-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib / Gusset Assembly

Start Date: 2/03/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/11/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

RL

Date: *10-2-03* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3826	Rev B

100		0.00
-----	--	------



Large Fab

Large Fab

Memo

0.00

Large Fab

1- use DT9434 to assemble D2325 support gusset together. 2- locate D2325 on rib and weld as per dwg D382611 A/R ER316 S.S. Rod
Batch: *4110*

4113328

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
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QC

Memo

0.00

Quality Control

120	QC5- Inspect part completeness to step on W/O	0.00
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QC

Memo

0.00

Quality Control

SL 10/02/12 *(6x)*

(6) 10/02/12

(6) 10/02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55841

February 3, 2010 10:46:46 AM



Page 2

Item ID: D3826-041

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Setup Start



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Item Name: Rib / Gusset Assembly

Start Date: 2/03/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/11/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Basket call
Memo

0.00

Packaging

SY 10/02/12 *(ca)*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/16 *MF**MF*
10-2-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 3, 2010 10:46:50 AM

Page 1

Work Order ID: 55841

Parent Item: D3826-041

Parent Item Name: Rib / Gusset Assembly



Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Date: 2/03/10

Required Date: 2/11/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2235-1		Manufactured	No				Each	10.0000	6.0000			
												
Basket Rib												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

10

50565

3

54864

7

Each

5.0000

6.0000

B55719 5x

1x

SY 10/02/12

D3929-041

Manufactured No



Gusset Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

5

54729

5

Each

19.0000

6.0000

B55720

1x

5x

SY 10/02/12

D3929-042

Manufactured No



Gusset Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

11

50567

2

50869

9

Main Warehouse

WA

8

54730

8

6x

SY 10/02/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

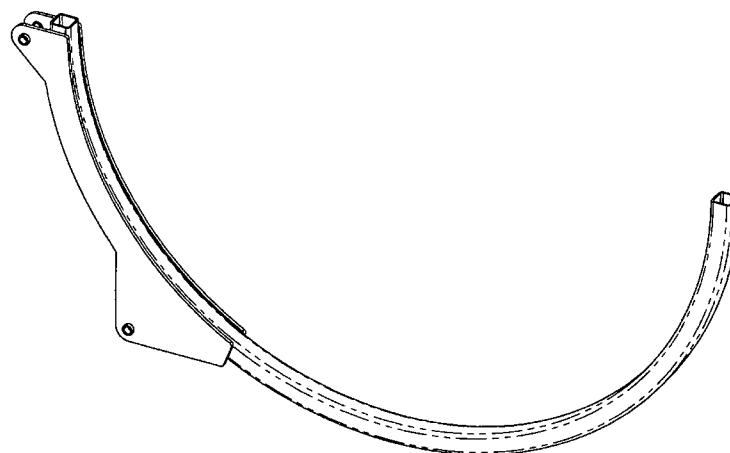
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

△B



D3826-041 RIB/GUSSET ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35841

10-2-03

RELEASED
5/10/12 MB

- NOTES:**
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 3.32 lbs

△B

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>16</i>		
DRAWN	<i>15</i>		
CHECKED	<i>14</i>		
MFG. APPR.	<i>13</i>		
APPROVED	<i>12</i>		
DE APPR.	<i>11</i>		
DATE	09.04.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3826** REV. B
SHEET 1 OF 2
TITLE **RIB/GUSSET ASSY** SCALE NTS

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△ B D3929-042
GUSSET ASSEMBLY

△ B D3929-041
GUSSET ASSEMBLY

TYP

0.250

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

RELEASED
9/04/16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
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